

Transfer of 2000

107

22 512

File Edit View Insert Format Records Tools Window Help									
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 838 839 840 841 842 843 844 845 846 847 848 849 850 851 852 853 854 855 856 857 858 859 860 861 862 863 864 865 866 867 868 869 870 871 872 873 874 875 876 877 878 879 880 881 882 883 884 885 886 887 888 889 890 891 892 893 894 895 896 897 898 899 900 901 902 903 904 905 906 907 908 909 910 911 912 913 914 915 916 917 918 919 920 921 922 923 924 925 926 927 928 929 930 931 932 933 934 935 936 937 938 939 940 941 942 943 944 945 946 947 948 949 950 951 952 953 954 955 956 957 958 959 960 961 962 963 964 965 966 967 968 969 970 971 972 973 974 975 976 977 978 979 980 981 982 983 984 985 986 987 988 989 990 991 992 993 994 995 996 997 998 999 1000									
Date	Shift	Equipment	System	Product Code	Lot Number	Submitted by:	Supervisor's Name	Group Leader's N	
01/03/2000	1	Line 1		1006	123456	Jose Inzary	Carmen Ramos	Brandy Chocolate	
01/03/2000	2	Line 1		1001	123456	Migdalia Rodrig	Short Fuse	Sammy Jimenez	
01/03/2000	3	Line 1		1001	123456	SI	Smart Dog	Denisse Brown	
01/04/2000	1	Line 1		1002	654321	JI	Carmen Ramos	Brandy Chocolate	
01/04/2000	2	Line 1		1002	654321	MR	Short Fuse	Sammy Jimenez	
01/04/2000	3	Line 1		1002	654321	SI	Smart Dog	Denisse Brown	
01/14/2000	1	Line 1		1001	90P0014	Carmen Gonzale	Short Fuse	Carmen Gonzalez	
01/15/2000	1	Line 1		1001	90P201	Rafael Lebron	Carmen Ramos	Jose Barreiro	
01/17/2000	1	Line 1		1001	90P0714	Evelyn Santiago	Evelyn Santiago	Jorge Medina	
01/18/2000	1	Line 1		1004	124365	JI	Carmen Ramos	Brandy Chocolate	
01/18/2000	2	Line 1		1004	124365	MR	Short Fuse	Sammy Jimenez	
01/18/2000	3	Line 1		1004	124365	SI	Smart Dog	Denisse Brown	
01/21/2000	1	Line 1		1001	90p0099Z	E Martinez	Eillen Bergquist	Ismael Olmedo	
01/22/2000	2	Line 1		1003	111111	JI	Carmen Ramos	Black Chip	
01/24/2000	1	Line 1		1001	90P0045	Jorge Burgos	Lucy Carrion	Jorge Burgos	
01/25/2000	1	Line 1		1001	90B004	Marisel Penistor	José Mejías	Graciela Claudio	
01/26/2000	1	Line 1		1001	90P0035E	Marissa Betanc	Manssa Betancourt	Ana Ocasio	
01/31/2000	1	Line 1		1001	567890	JI	Carmen Ramos	Brandy Chocolate	
01/31/2000	2	Line 1		1001	567890	MR	Short Fuse	Sammy Jimenez	
01/31/2000	3	Line 1		1001	567890	SI	Smart Dog	Denisse Brown	

Record 16 of 20

Database View

Fig. 1 24

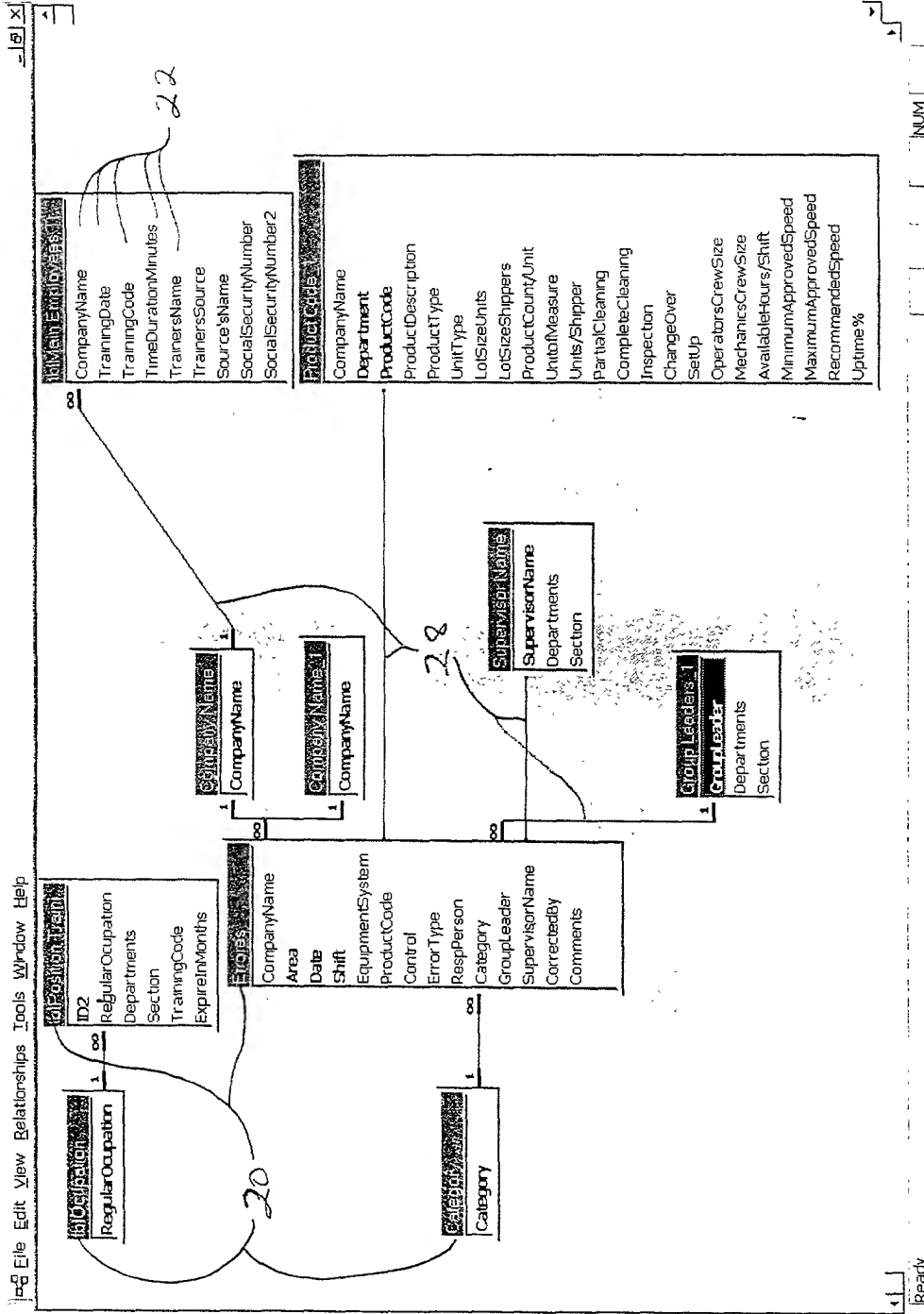


Fig. 2

Date: (mm/dd/yyyy)
01/03/2000

Shift
1

Equipment System
Line 1

Product Code
1006

Lot Number
123456

Submitted by:
Jose Lizary

Supervisor's Name:
Carmen Ramos

Group Leader's Name:
Brandy Chocolate

Mechanic's Name:
Ugly Guy

QC Inspector's Name:
Old Man

Operators
7

*Partial Cleaning
30

*Complete Cleaning
60

*Change Over
120

*Inspection
10

*Set Up
10

Units /Shipper (U/Min)
200

*Time in Minutes
175

Operators
7

*Partial Cleaning
0

*Complete Cleaning
90

*Change Over
120

*Inspection
16

*Set Up
15

*Breaks
45

Shift Hour: 1st
20

2nd
100

3rd
25

4th
23

5th
14

6th
18

7th
32

8th
30

Totals
262

Shippers: 4,000

Units: 20,000

3,000

4,600

2,800

3,600

6,400

6,000

52,400

Product Run Alert
☒

Alert Category
Broken Tablets

Alert Details
☒

Tablets are found broken Source of origin for breakage is unknown

Daily Production Module

Downline Module

Reports Menu

Actual vs Plan

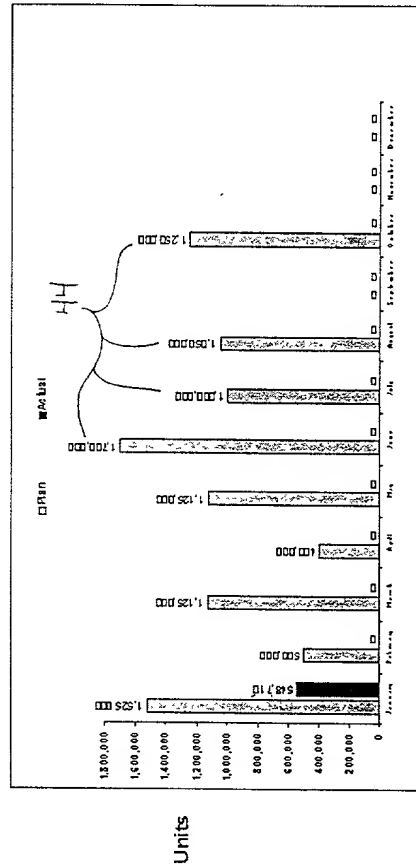
57

402

Actual vs Plan by Equipment System

Wonder Pharmaceuticals Inc.

Year: 2000



Plan Total: 9,675,000
Actual Total: 548,710
Actual Volume Variance (Units) For The Year: -9,126,290
Actual Volume (Percent of Plan): 5.67%

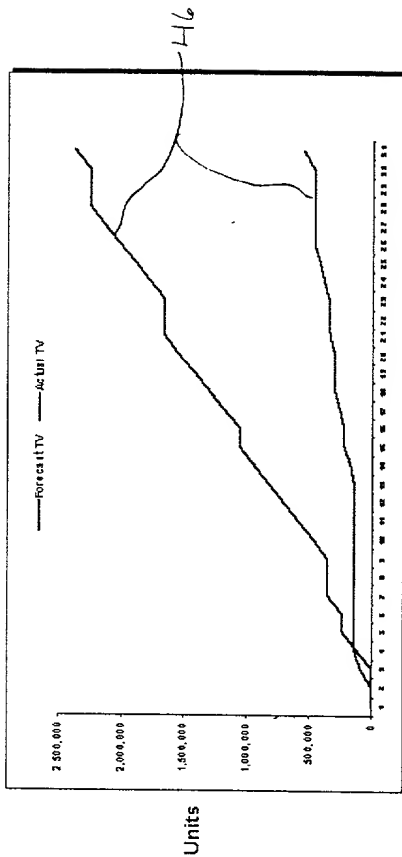
Wednesday, July 19, 2000

Director by Business Systems

Fig. 4

407

Actual vs Forecast Cumulative Volume
Wonder Pharmaceuticals Inc.
Date Period: from 01/01/2000 to 01/31/2000
All Shift:



Actual Volume Variance (Units) For The Period: -1,821,290

Director by BusinessSense Inc

Wednesday, July 19, 2000

407

Actual vs Plan by Equipment System
For Line 1

Wonder Pharmaceuticals Inc.

Year: 2000

Plan Total: 9,675,000 Actual Volume Variance (Units) For The Year: -9,126,290
 Actual Total: 548,710 Actual Volume (Percent of Plan): 5.67%

Month	Plan Volume	Actual Volume	Variance	Percent
January	1,525,000	548,710	9,126,290	35.98%
February	500,000	0	9,126,290	0.00%
March	1,125,000	0	-9,126,290	0.00%
April	400,000	0	-9,126,290	0.00%
May	1,125,000	0	-9,126,290	0.00%
June	1,700,000	0	-9,126,290	0.00%
July	1,000,000	0	-9,126,290	0.00%
August	1,050,000	0	-9,126,290	0.00%
September	0	0	-9,126,290	0.00%
October	1,250,000	0	-9,126,290	0.00%
November	0	0	9,126,290	0.00%
December	0	0	-9,126,290	0.00%

Director by Bureau Services Inc.

Wednesday, July 19, 2000

Page 1 of 1

44

Fig. 6

40

Product Run Alert Report

Won

Data Period: From 01/01/2000 to 01/31/2000

42

Line	Item	Product Description	Lot#	Date	SALE	Supplier	Group/Leader	Material	QC In Spec	Shipped	Units	Alert
Line 1	1001	Worster Cough Medicine	12-206	01/02/2000	2	Sherrill Inc	Perdue Brown	John Figueroa	Carlos Ruiz	112	8,500	Broken
Line 1	1001	Worster Cough Medicine	12-206	01/02/2000	2	Sherrill Inc	Sammy Jimenez	Carlos Ruiz	Miguel Ruiz	250	33,000	Broken
Line 1	1001	Worster Cough Medicine	12-206	01/02/2000	1	Carman Ramos	Barry Chocklet	lighting	Old Item	110	13,800	Broken
Line 1	1001	Worster Medicate Medicine	501011	01/14/2000	1	Sherrill Inc	Carman Ovantes	Carlos Ruiz	Old Item	206	25,500	Broken
Line 1	1001	Worster Medicate Medicine	501010E	01/02/2000	1	Markus Behrman	Ana Gomez	Fernando Arroyo	Old Item	406	46,500	Broken
Line 1	1001	Worster Hemlock Medicine	5010101	01/02/2000	1	Carman Ramos	Jose Barrios	John Figueroa	Carlos Ruiz	516	51,500	Broken

44

Director by Business Sense Inc

Wednesday, July 19 2000

Fig. 7

NUM

1999 Copyright Business Sense Inc.

Productivity Recovery And Improvement
Software For Manufacturing Areas

Official Annual Forecast

Capacity Analysis

Production Monthly Plan

Forecast Days Of The Month

Daily Production Module

Downtime Module

Production Waste Module

Documentation Errors Module

Personnel Training Module

Tables Update

Exit Database

Fig 8

TT99350 2799350

File Edit View Insert Format Records Tools Window Help

Favorites Go

Production Waste Module		Business Sense Inc.	
Date: (mm/dd/yyyy)	Shift	Equipment System	Lot Number
01/01/2000	2	Line 1	123456
Waste Source	Component Code	Quantity	Unit of Measure
Change Over & Setup	123456	100 0000	Each
Production Waste Module			
30~ 525		38	
Reports		Menu	
Record: 11		1 of 1	

Form View

Fig. 9

FIG. 10

Dissector

File Edit View Insert Format Records Tools Window Help

Business Sense Inc.

Documentation Errors Module

Company Name Wonder Pharmaceuticals Inc		Date 1/1/00	Area Packaging	Shift 1	Equipment System Line 1
Product Code 1001	Lot Number 12345	Error Type Blank Spaces	Error Creator Employee # 3		
Employment Category Regular	Group Leader Brandy Chocolate	Supervisor's Name Smart Dog	Corrected By Merry Christmas		
Comments					

Documentation Errors Module



20

S2

38

30

Repeat Header

Reports Menu

Print

Exit

Record: 14 of 11

FIG. 11

Official Annual Forecast		Business Sense Inc.	
Official Annual Forecast — 52			
<u>Time Period</u>			
Date	Production Area	Period From	Period To
11/20/1999	Packaging	01/01/2000	12/31/2000
<u>Annual Volume Lots</u>			
Equipment System	Product Code	Month	Lots
Line 1	1001	September	0
30 ~		38	
Add Lots		New Product	
50		15	
Record: 14 of 72			

Production Capacity Analysis Form				Business Sense Inc.	
Production Capacity Analysis Form					
<u>Heading Data</u>		<u>S2</u>			
Date	Forecast Heading	Period From	Period To		
11/20/2000	Wonder Pharmaceuticals Inc. For	01/01/2000	12/31/2000		
Calendar Days	Holidays	Shut Down Days			
366	12	21			
<u>Product Data:</u>					
Product Code	Total Lots	Total Groups	Group Size	Equipment System	
1001	140	3	5	Line 1	
30		38		Report	
Record: 14 of 9					

Dissector

File Edit View Insert Format Records Tools Window Help

Downtime Module		Business Sense Inc.	
Date: (mm/dd/yyyy)	Shift	Equipment System	Lot Number
1/23/00	1	Line 1	123456
Equipment Code	Downtime Code		
Label 1	Lab 1 2		
Downtime Description			
Label rolls break frequently			
Action Taken			
Label roll tension was adjusted to prevent breakage			
Action Taken Category			
Adjustments			
Area Responsible For Downtime			
Maintenance			
Best Solution Criteria			
Standardize Adjustments			

Equipment System Downtime	
Start Time	End Time
7:30	9:32
Equipment Downtime	
Start Time	End Time
Equipment System Downtime (Minutes)	
	122
Equipment Downtime (Minutes)	

Downtime Module	
Repeat Header	
52	38
Reports Menu	

Record: 14 of 28

FIG. 14

Production Monthly Plan

Business Sense Inc.

527 Production Monthly Plan

Date

12/28/1999

Equipment System

Line 1

Period From

01/01/2000

Period To

01/31/2000

Update Plan

34

Year

2000

Month

January

Product Code

1001

Total Lots

6

30

38

Add More Lots

30

38

30

Record: 14 of 11

Forecast Days of The Month				Business Sense Inc.	
Equipment System	Period From	Period To	Total Lots	Total Units	
Line 1	01 Jan-2000	31 Jan-2000	21	2,370,000	
52 Forecast Days of The Month					
Shift 1	Shift 2	Shift 3	Shift 1	Shift 2	Shift 3
1	2	3	4	5	6
7	8	9	10	11	12
13	14	15	16	17	18
19	20	21	22	23	24
25	26	27	28	29	30
31	32	33	34	35	36
37	38	39	40	41	42
43	44	45	46	47	48
49	50	51	52	53	54
55	56	57	58	59	60
61	62	63	64	65	66
67	68	69	70	71	72
73	74	75	76	77	78
79	80	81	82	83	84
85	86	87	88	89	90
91	92	93	94	95	96
97	98	99	100	101	102
103	104	105	106	107	108
109	110	111	112	113	114
115	116	117	118	119	120
121	122	123	124	125	126
127	128	129	130	131	132
133	134	135	136	137	138
139	140	141	142	143	144
145	146	147	148	149	150
151	152	153	154	155	156
157	158	159	160	161	162
163	164	165	166	167	168
169	170	171	172	173	174
175	176	177	178	179	180
181	182	183	184	185	186
187	188	189	190	191	192
193	194	195	196	197	198
199	200	201	202	203	204
205	206	207	208	209	210
211	212	213	214	215	216
217	218	219	220	221	222
223	224	225	226	227	228
229	230	231	232	233	234
235	236	237	238	239	240
241	242	243	244	245	246
247	248	249	250	251	252
253	254	255	256	257	258
259	260	261	262	263	264
265	266	267	268	269	270
271	272	273	274	275	276
277	278	279	280	281	282
283	284	285	286	287	288
289	290	291	292	293	294
295	296	297	298	299	300
301	302	303	304	305	306
307	308	309	310	311	312
313	314	315	316	317	318
319	320	321	322	323	324
325	326	327	328	329	330
331	332	333	334	335	336
337	338	339	340	341	342
343	344	345	346	347	348
349	350	351	352	353	354
355	356	357	358	359	360
361	362	363	364	365	366
367	368	369	370	371	372
373	374	375	376	377	378
379	380	381	382	383	384
385	386	387	388	389	390
391	392	393	394	395	396
397	398	399	400	401	402
403	404	405	406	407	408
409	410	411	412	413	414
415	416	417	418	419	420
421	422	423	424	425	426
427	428	429	430	431	432
433	434	435	436	437	438
439	440	441	442	443	444
445	446	447	448	449	450
451	452	453	454	455	456
457	458	459	460	461	462
463	464	465	466	467	468
469	470	471	472	473	474
475	476	477	478	479	480
481	482	483	484	485	486
487	488	489	490	491	492
493	494	495	496	497	498
499	500	501	502	503	504
505	506	507	508	509	510
511	512	513	514	515	516
517	518	519	520	521	522
523	524	525	526	527	528
529	530	531	532	533	534
535	536	537	538	539	540
541	542	543	544	545	546
547	548	549	550	551	552
553	554	555	556	557	558
559	560	561	562	563	564
565	566	567	568	569	570
571	572	573	574	575	576
577	578	579	580	581	582
583	584	585	586	587	588
589	590	591	592	593	594
595	596	597	598	599	600
601	602	603	604	605	606
607	608	609	610	611	612
613	614	615	616	617	618
619	620	621	622	623	624
625	626	627	628	629	630
631	632	633	634	635	636
637	638	639	640	641	642
643	644	645	646	647	648
649	650	651	652	653	654
655	656	657	658	659	660
661	662	663	664	665	666
667	668	669	670	671	672
673	674	675	676	677	678
679	680	681	682	683	684
685	686	687	688	689	690
691	692	693	694	695	696
697	698	699	700	701	702
703	704	705	706	707	708
709	710	711	712	713	714
715	716	717	718	719	720
721	722	723	724	725	726
727	728	729	730	731	732
733	734	735	736	737	738
739	740	741	742	743	744
745	746	747	748	749	750
751	752	753	754	755	756
757	758	759	760	761	762
763	764	765	766	767	768
769	770	771	772	773	774
775	776	777	778	779	780
781	782	783	784	785	786
787	788	789	790	791	792
793	794	795	796	797	798
799	800	801	802	803	804
805	806	807	808	809	810
811	812	813	814	815	816
817	818	819	820	821	822
823	824	825	826	827	828
829	830	831	832	833	834
835	836	837	838	839	840
841	842	843	844	845	846
847	848	849	850	851	852
853	854	855	856	857	858
859	860	861	862	863	864
865	866	867	868	869	870
871	872	873	874	875	876
877	878	879	880	881	882
883	884	885	886	887	888
889	890	891	892	893	894
895	896	897	898	899	900
901	902	903	904	905	906
907	908	909	910	911	912
913	914	915	916	917	918
919	920	921	922	923	924
925	926	927	928	929	930
931	932	933	934	935	936
937	938	939	940	941	942
943	944	945	946	947	948
949	950	951	952	953	954
955	956	957	958	959	960
961	962	963	964	965	966
967	968	969	970	971	972
973	974	975	976	977	978
979	980	981	982	983	984
985	986	987	988	989	990
991	992	993	994	995	996
997	998	999	1000	1001	1002
1003	1004	1005	1006	1007	1008
1009	1010	1011	1012	1013	1014
1015	1016	1017	1018	1019	1020
1021	1022	1023	1024	1025	1026
1027	1028	1029	1030	1031	1032
1033	1034	1035	1036	1037	1038
1039	1040	1041	1042	1043	1044
1045	1046	1047	1048	1049	1050
1051	1052	1053	1054	1055	1056
1057	1058	1059	1060	1061	1062
1063	1064	1065	1066	1067	1068
1069	1070	1071	1072	1073	1074
1075	1076	1077	1078	1079	1080
1081	1082	1083	1084	1085	1086
1087	1088	1089	1090	1091	1092
1093	1094	1095	1096	1097	1098
1099	1100	1101	1102	1103	1104
1105	1106	1107	1108	1109	1110
1111	1112	1113	1114	1115	1116
1117	1118	1119	1120	1121	1122
1123	1124	1125	1126	1127	1128
1129	1130	1131	1132	1133	1134
1135	1136	1137	1138	1139	1140
1141	1142	1143	1144	1145	1146
1147	1148	1149	1150	1151	1152
1153	1154	1155	1156	1157	1158
1159	1160	1161	1162	1163	1164
1165	1166	1167	1168	1169	1170
1171	1172	1173	1174	1175	1176
1177	1178	1179	1180	1181	1182
1183	1184	1185	1186	1187	1188
1189	1190	1191	1192	1193	1194
1195	1196	1197	1198	1199	1200
1201	1202	1203	1204	1205	1206
1207	1208	1209	1210	1211	1212
1213	1214	1215	1216	1217	1218
1219	1220	1221	1222	1223	1224
1225	1226	1227	1228	1229	1230
1231	1232	1233	1234	1235	1236
1237	1238	1239	1240	1241	1242
1243	1244	1245	1246	1247	1248
1249	1250	1251	1252	1253	1254
1255	1256	1257	1258	1259	1260
1261	1262	1263	1264	1265	1266
1267	1268	1269	1270	1271	1272
1273	1274	1275	1276	1277	1278
1279	1280	1281	1282	1283	1284
1285	1286	1287	1288	1289	1290
1291	1292	1293	1294	1295	1296
1297	1298	1299	1300	1301	1302
1303	1304	1305	1306	1307	1308
1309	1310	1311	1312	1313	1314
1315	1316	1317	1318	1319	1320
1321	1322	1323			

Product Code Table		Business Sense Inc.	
Product Code Table Company Name: Business Sense Inc.		Product Description:	
Production Area	Product Code	Product Description	Product Type
Packaging	1	Product 1	Tablets
Unit Type	Lot Size (Units)	Lot Size (Shippers)	Unit Count
Bottle	8,016	167	100
Standards:* (Time in Minutes)		Unit Of Measure	Units / Shipper
Partial Cleaning Time*	Complete Cleaning Time*	Each	48
45	75		
Standards:* (Time in Minutes)		Change Over Time*	Set Up Time*
45	75	60	60
Operators Crew Size	Mechanics Crew Size	Uptime %	
7	1	60.0	
Validation Values:		Available Hours / Shift	
Minimum Approved Speed (U/Min)	Maximum Approved Speed (U/Min)		
60	100		
Recommended Speed (U/Min)			
90			
Product Codes Report			
Record 14 of 119			

FIG. 17